

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WELDMENT TOP PANEL		
Job Number	: 42094			Part Number	: D36501		
Estimate Number	: 13028			Drawing Number	: D3650 REV.B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 18/09/2008 S.O. No. :			Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 25/09/2008 Qty: 5 Um: Each		
Previous Run	: 39932						
Written By	:						
Checked & Approved By	: JND 08.9.18						
Comment	: Est Rev:A New Issue 07-09-27 DD verified by: EC						
	Est Rev:B ECN 1113P 08-01-22 DD verified by: EC						
	Est Rev:C ecn1162 08-04-02 DD verified by: EC						

## Additional Product

Job Number:

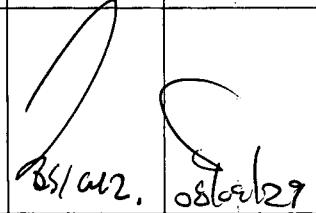
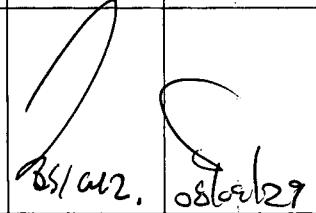


Seq. #:	Machine Or Operation:	Description :	
1.0	M304S26GA	304/316 0.018 SHEET	
		Comment: Qty.: 1.6622 sf(s)/Unit Total : 8.3108 sf(s) 304/316 SS sheet 26 ga (0.018" thick) Batch: 109398 HB 8-9-26	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3650 Dwg Rev: B HB 8-9-26 Prog Rev: B	(b)
		2-Deburr if necessary HB 8-9-26	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		FR 8-9-26	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		SB 08/08/28 (46)	
		Comment: SECOND CHECK	
5.0	BRAKE NC	NC BRAKE	
		PT 8	
		Comment: NC BRAKE Form as per Dwg D3650	5
		SB 08/09/30	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3650-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/10/03

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 42094		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/09/03	20	Part found with scratches 0.005" scribbled in it. P.C was on part.		Part is too thin after trying to remove scratches. Scrap and destroy no replace extra was cut on water jet.	8/10/03 08/09/03			
				(Part is too thin after trying to remove scratches.) Scratch still shows.				

NOTE: Date & initial all entries

Date: Thursday, 18/09/2008 11:12:31 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WELDMENT TOP PANEL

Job Number: 42094

Part Number: D36501

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 QC5

INSPECT WORK TO CURRENT STEP



S 08/04/30 45

Comment: INSPECT WORK TO CURRENT STEP

7.0 MS20427M33

Rivet



Comment: Qty.: 18.0000 Each(s)/Unit Total : 90.0000 Each(s)

Rivet

batch: 1109371

FF 08/10/01

5

8.0 MS210603K

Nut Plate



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Nut Plate

batch: 1109371

FF 08/10/01

5

9.0 MS210623K

Nut Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s)

Nut Plate

batch: 1108669

FF 08/10/01

5

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3650

INSPECT WORK TO CURRENT STEP

FF 08/10/01 5

11.0 QC5



Comment: INSPECT WORK TO CURRENT STEP

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: ~~SA~~

08/10/02 SD

5

13.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MF 08-10-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42094
Description: Aft Panel		Part Number: D3650-1
Inspection Dwg: D3650	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

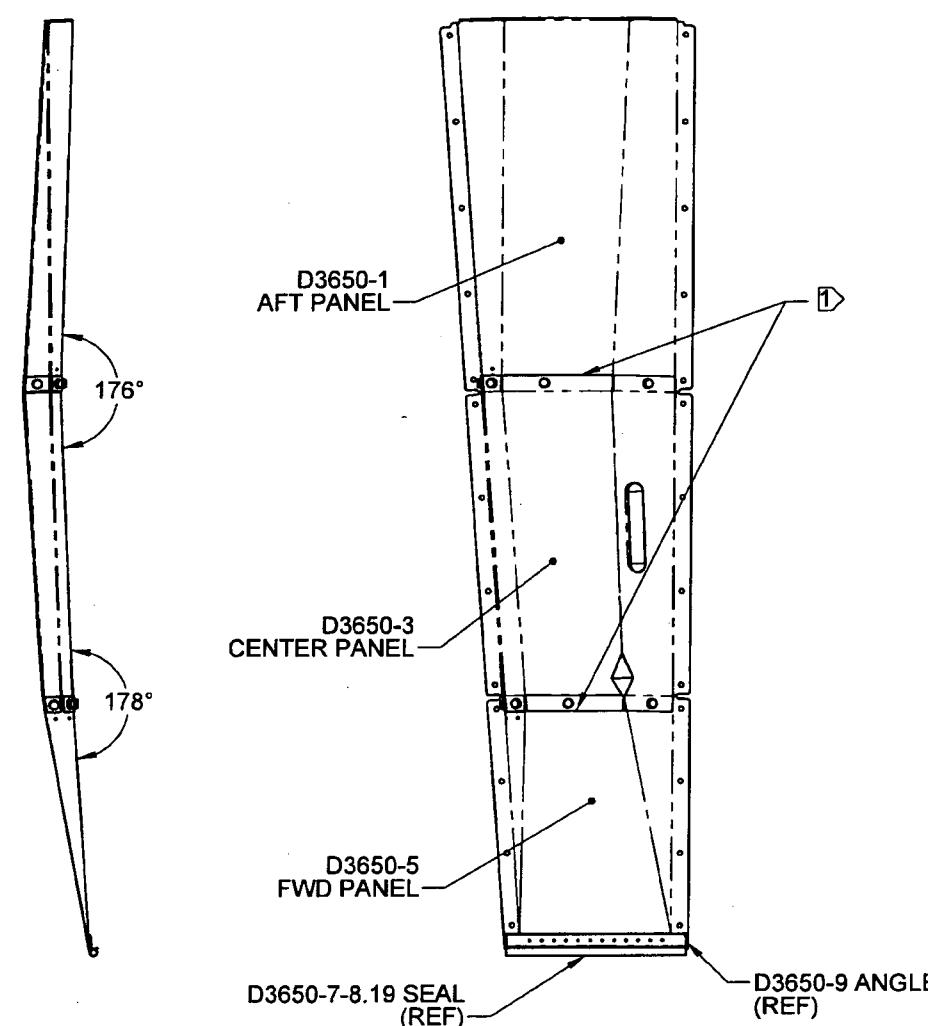
First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.161	X			
Ø0.213	+0.005/-0.001	.216	X			
Ø0.250	+0.005/-0.001	.254	X			
0.35	+/-0.030	.353	X			
0.344	+/-0.010	.345	X			
0.312	+/-0.010	.316	X			
12.02	+/-0.030	12.02	X			
12.25	+/-0.030	12.20	X			
16.65	+/-0.030	16.28	X			
17.58	+/-0.030	17.58	X			
16.61	+/-0.030	16.61	X			
15.80	+/-0.030	15.80	X			
3.950	+/-0.010	3.950	X			
2.26	+/-0.030	2.259	X			
7.18	+/-0.030	7.185	X			
9.55	+/-0.030	9.55	X			
10.66	+/-0.030	10.66	X			
0.40	+/-0.030	.401	X			
2.02	+/-0.030	2.025	X			
4.03	+/-0.030	4.027	X			
6.13	+/-0.030	6.134	X			
8.23	+/-0.030	8.233	X			
10.31	+/-0.030	10.31	X			

Measured by: HB	Audited by: S	Prototype Approval: N/A
Date: 8-9-26	Date: 08/08/29	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD	AS

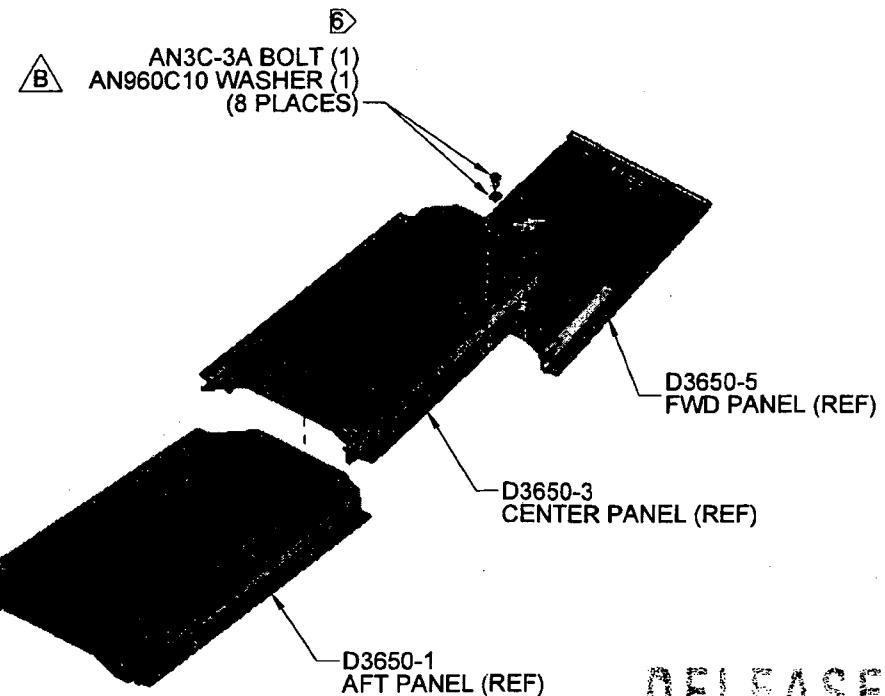
8 7 6 5 4 3 2 1



D3650-041 TUNNEL TOP PANEL ASSEMBLY

NOTES:

- 1) SEAL ALL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: NONE
- 6) TORQUE FASTENERS 15 TO 25 in-lb
- 7) WEIGHT: 3.3 lbs



PART LIST

QTY	PART NUMBER	DESCRIPTION
X	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER

B	SHEETS 1, 2 & 7: UPDATED FASTENER QUANTITIES; UPDATED VIEWS SHEETS 3 & 8: REMOVED/RELOCATED HOLES; UPDATED VIEWS SHEET 4: 1.8 WAS 1.5; 1.0 WAS 0.8; UPDATED VIEW; ADDED NOTE 8 SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS; UPDATED VIEWS SHEET 6: REMOVED/RELOCATED HOLES & ADDED CUTOUT TO D3650-3F; MOVED D3650-11-11F TO SHEET 9; ADDED DETAIL 1 SHEET 9: RELOCATED D3650-11-11F FROM SHEET 6; UPDATED DIMS OF D3650-11-11F	RF	08.01.07
A	NEW ISSUE	RF	07.11.07

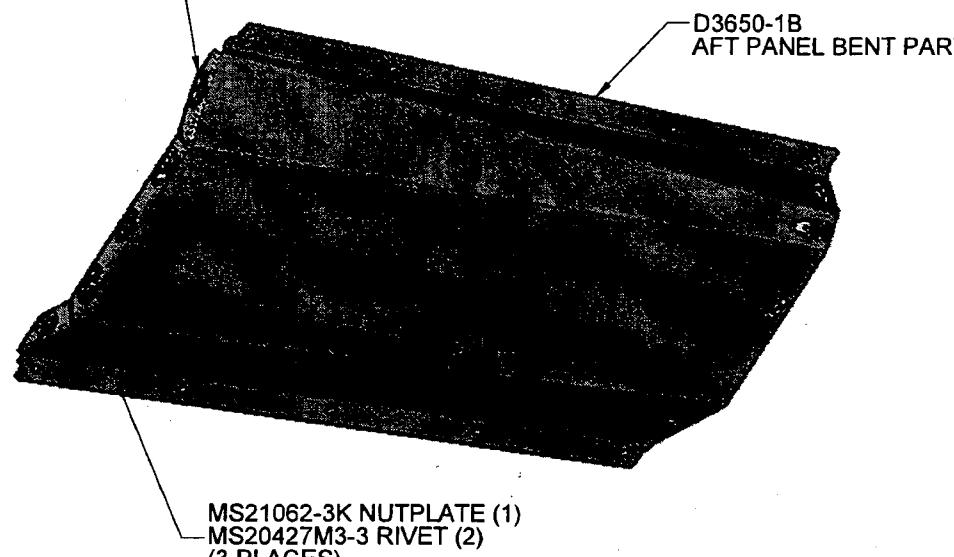
REV.	DESCRIPTION	BY	DATE

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	
MFG. APPR.	MM	REV. B	
APPROVED	MM	D3650	
DE APPR.	MM	SHEET 1 OF 1	
DATE	08.01.07	TOP PANEL ASSEMBLY	SHOP COPY
			RETURN TO
			ENGINEERING
			UNCONTROLLED COPY
			SUBJECT TO AMENDMENT
			WITHOUT NOTICE
			WORK ORDER
			NO. 4001

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8 7 6 5 4 3 2 1

MS21060-3K NUTPLATE (1)  
MS20427M3-3 RIVET (2)  
(6 PLACES)

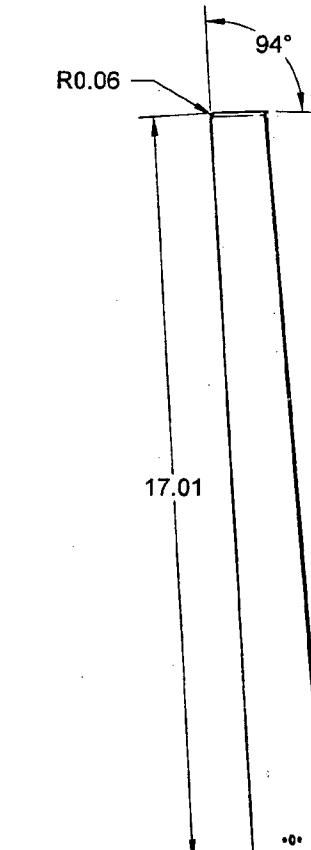
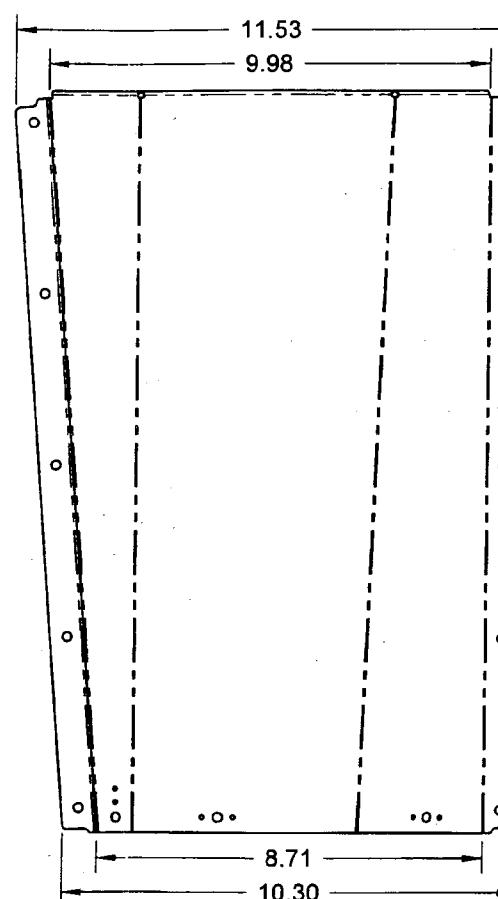
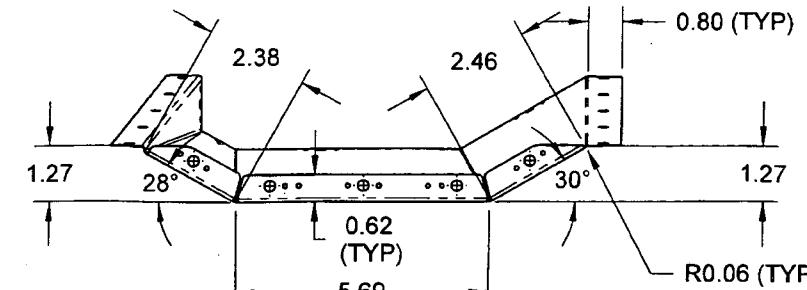


### D3650-1 AFT PANEL

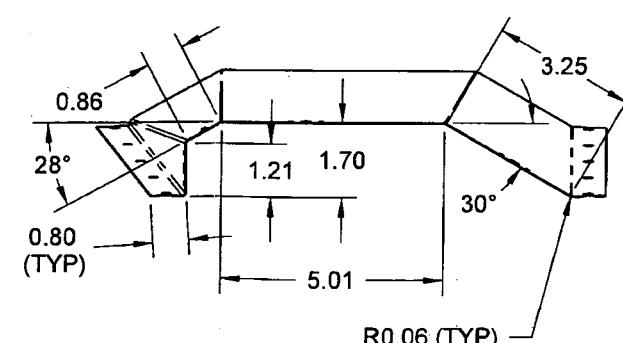
#### PART LIST

QTY -1	PART NUMBER	DESCRIPTION
X	D3650-1	AFT PANEL
1	D3650-1B	AFT PANEL BENT PART
18	MS20427M3-3	RIVET
6	MS21060-3K	NUTPLATE
3	MS21062-3K	NUT PLATE

B



**D3650-1B AFT PANEL BENT PART**  
(MAKE FROM D3650-1F FLAT PATTERN)



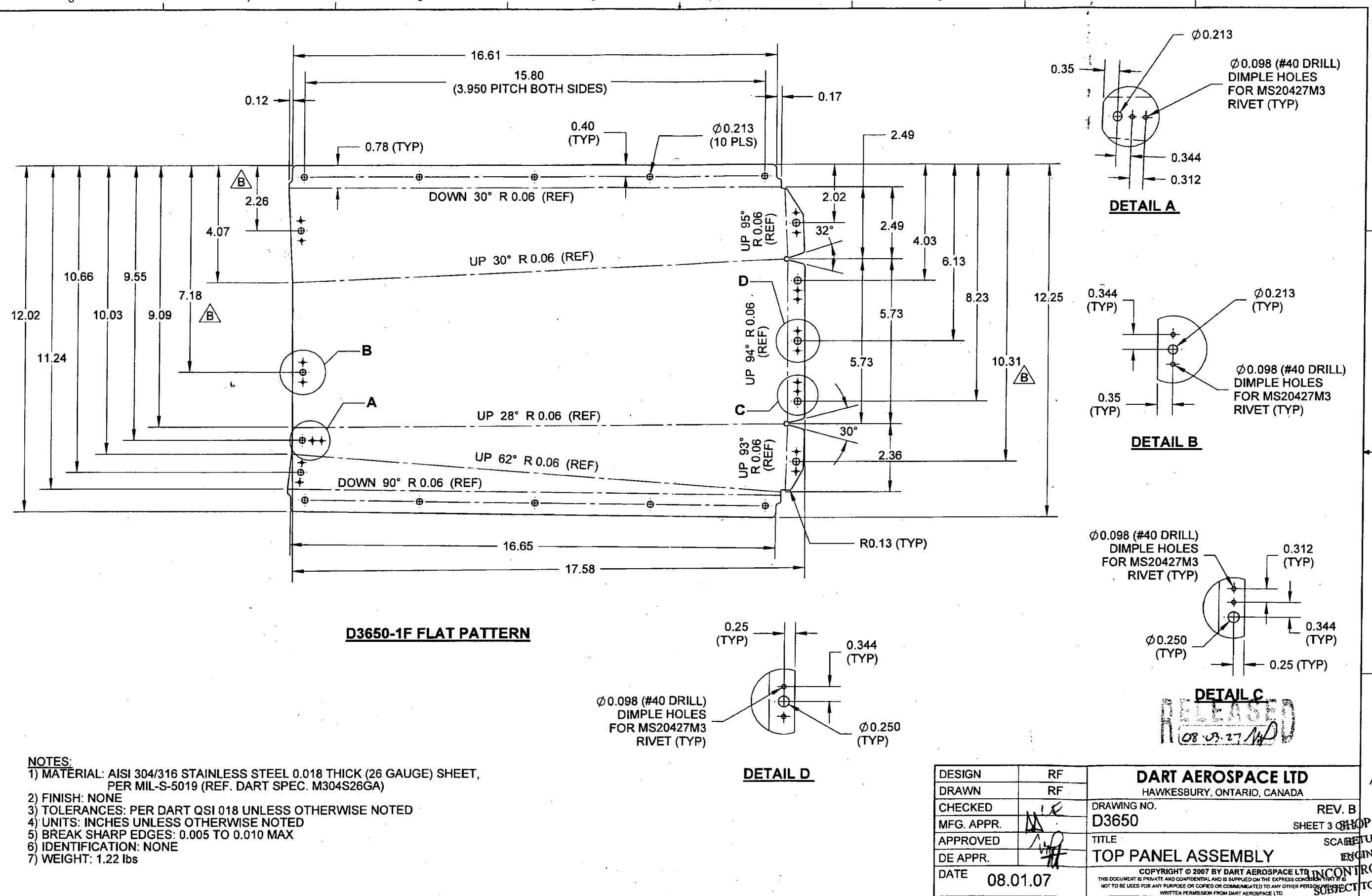
DESIGN	RF	<b>DART AEROSPACE LTD</b>
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>lu</i>	DRAWING NO.
MFG. APPR.	<i>lu</i>	REV. B
APPROVED	<i>lu</i>	D3650
DE APPR.	<i>lu</i>	SHEET 2 OF 9
DATE	08.01.07	TITLE
		TOP PANEL ASSEMBLY

RELEASED  
08-03-27 AM

NOTES:  
1) FINISH: NONE  
2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) UNITS: INCHES UNLESS OTHERWISE NOTED  
4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
5) IDENTIFICATION: NONE  
6) WEIGHT: 1.3 lbs

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WITHOUT NOTICE  
WORK ORDER  
NO. *0001*



## NOTES

**NOTE:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET  
PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.22 lbs

## **D3650-1F FLAT PATTERN**

Ø 0.098 (#40 DRILL)  
DIMPLE HOLES  
FOR MS20427M3  
RIVET (TYP)

## DETAIL C

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

## HAWKESBURY, ONTARIO, CANADA

REV. B

ET 3 OF 10 COPY

SCARE RETURN TO

## ENGINEERING

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ON THAT IT IS  
ON WHICH THE  
EFFECT TO AMEND

WITHOUT NOTICE

WORK ORD.

NO 42092

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2. **WITHOUT NOTICE** **IF** **EVER**

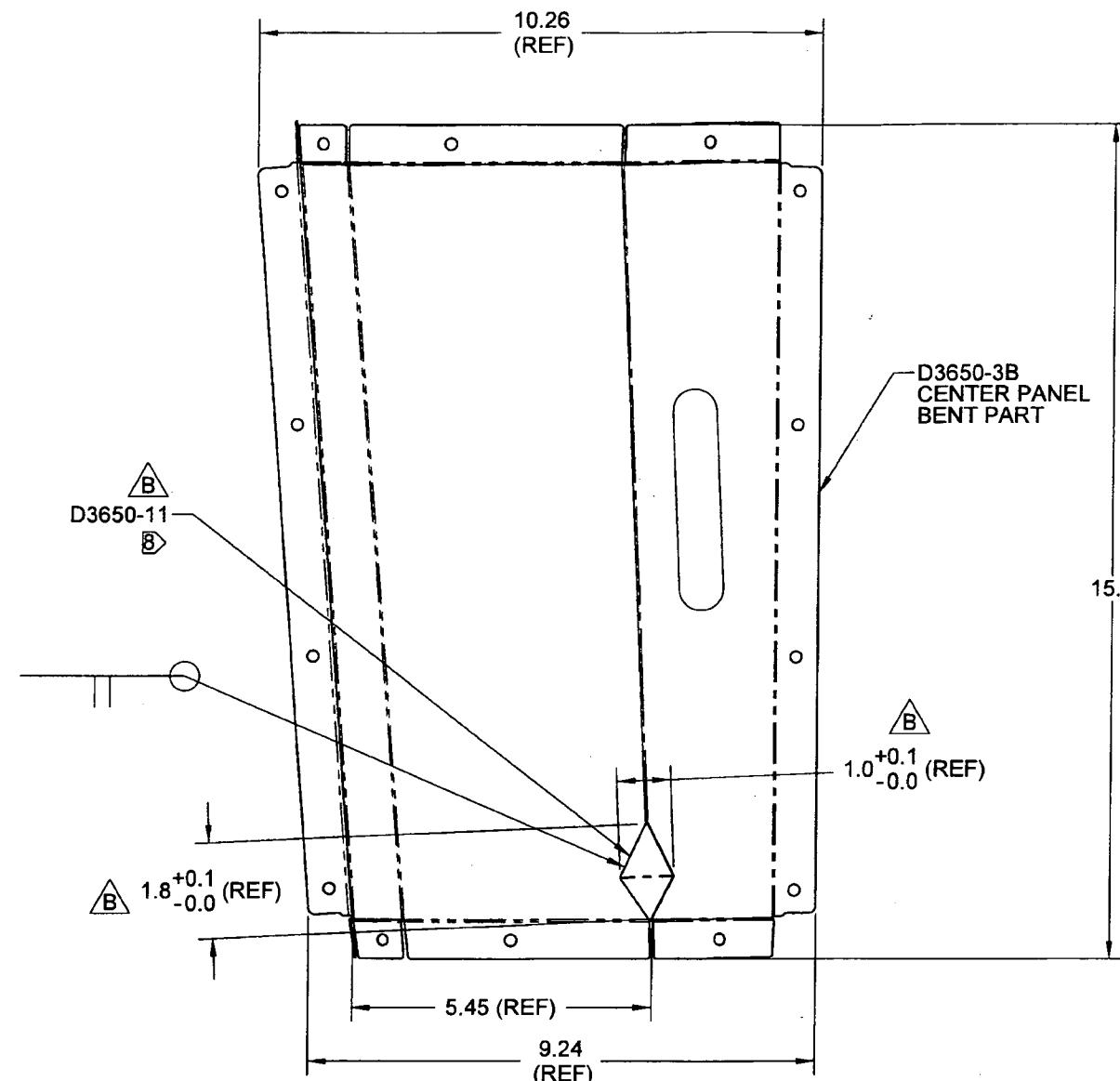
WORK ORDER

19. *Leucosia* *leucostoma* (Fabricius) (Fig. 19)

11. *What is the best way to increase the number of people who use a particular service?*

WITHOUT NOTICE  
WORK ORDER  
10.42094

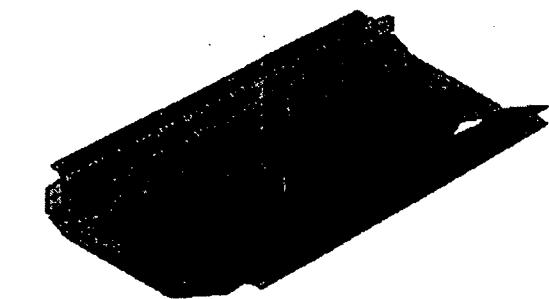
8 7 6 5 4 3 2 1



D3650-3 CENTER PANEL

NOTES:

- 1) WELD PER QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.0 lb
- 8) TRIM D3650-11 TO FIT AS REQUIRED



PART LIST

QTY	PART NUMBER	DESCRIPTION
-3	X D3650-3	CENTER PANEL
1	D3650-3B	CENTER PANEL BENT PART
1	D3650-11	FILLER PLATE

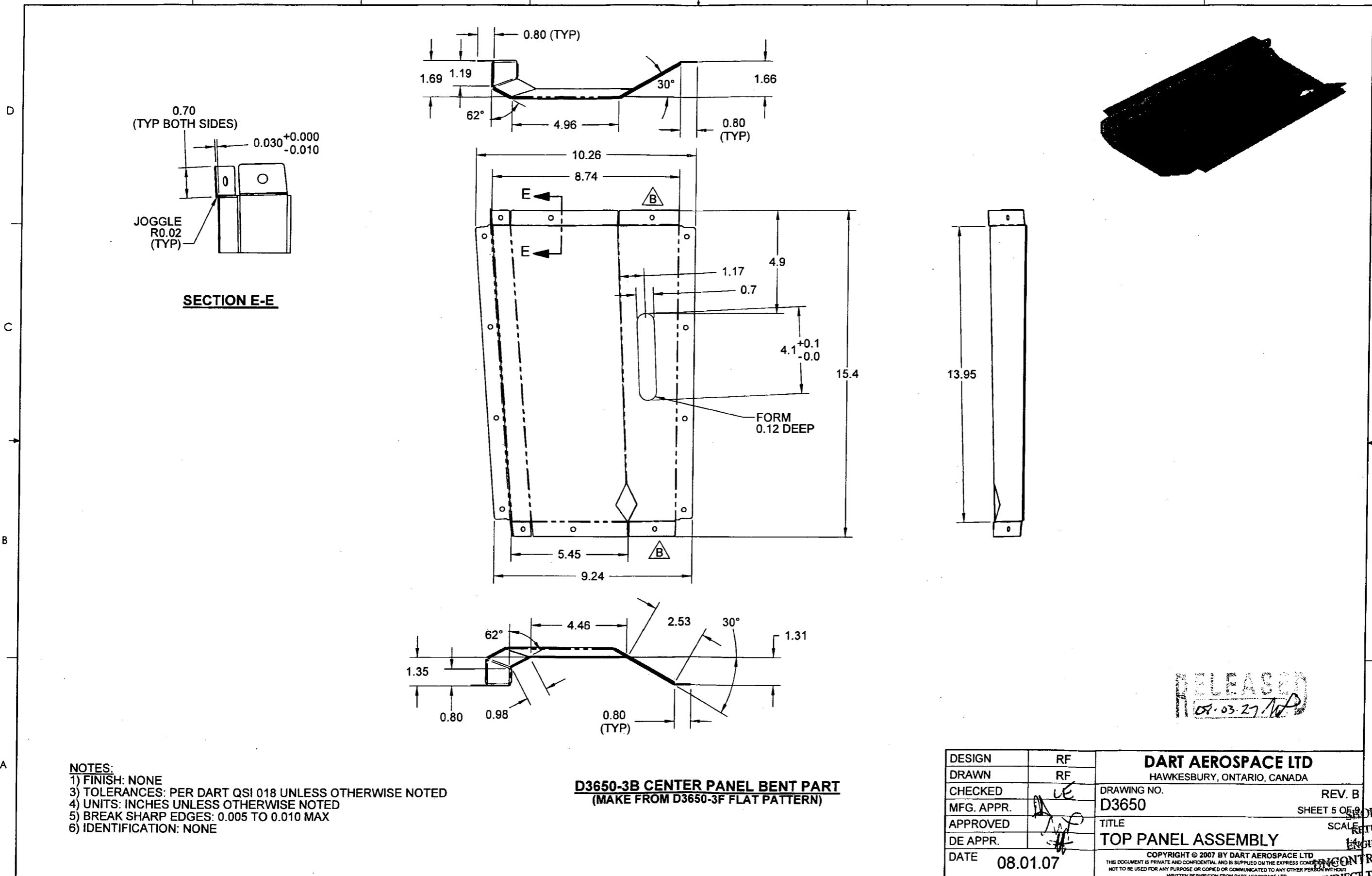
RELEASED  
08.03.27 100

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	
MFG. APPR.	DA	D3650	REV. B
APPROVED	MA	TITLE	SHEET 4 OF 9
DE APPR.	MA	TOP PANEL ASSEMBLY	SCALE 1:3
DATE	08.01.07	13	INCONTROLLED COPY

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WORK ORDER  
NO. 10017

8 7 6 5 4 3 2 1

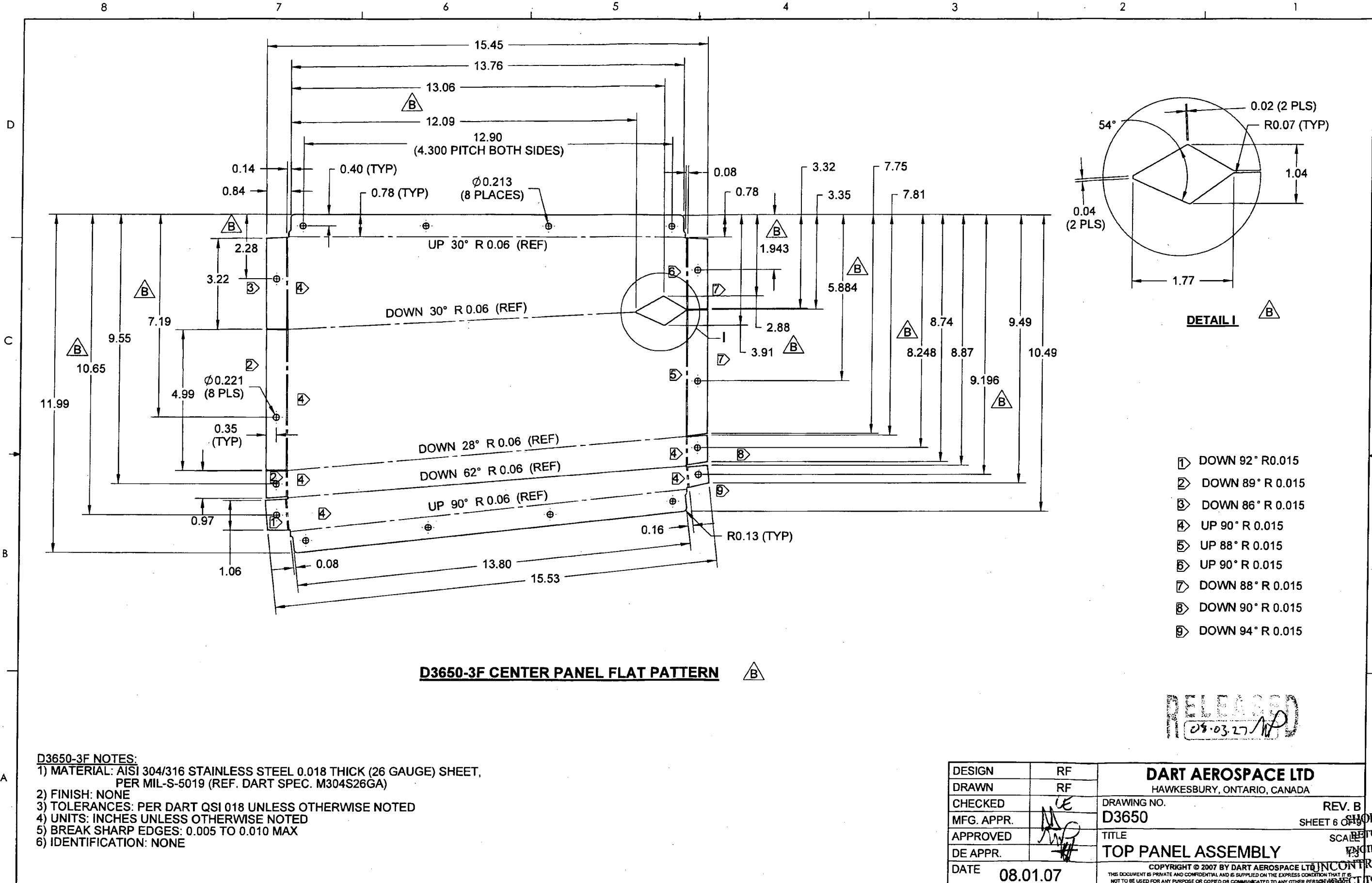


DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	LE	DRAWING NO.
MFG. APPR.	LE	REV. B
APPROVED	LE	D3650
DE APPR.	LE	SHEET 5 OF 9
DATE	08.01.07	TOP COPY

**TOP PANEL ASSEMBLY**

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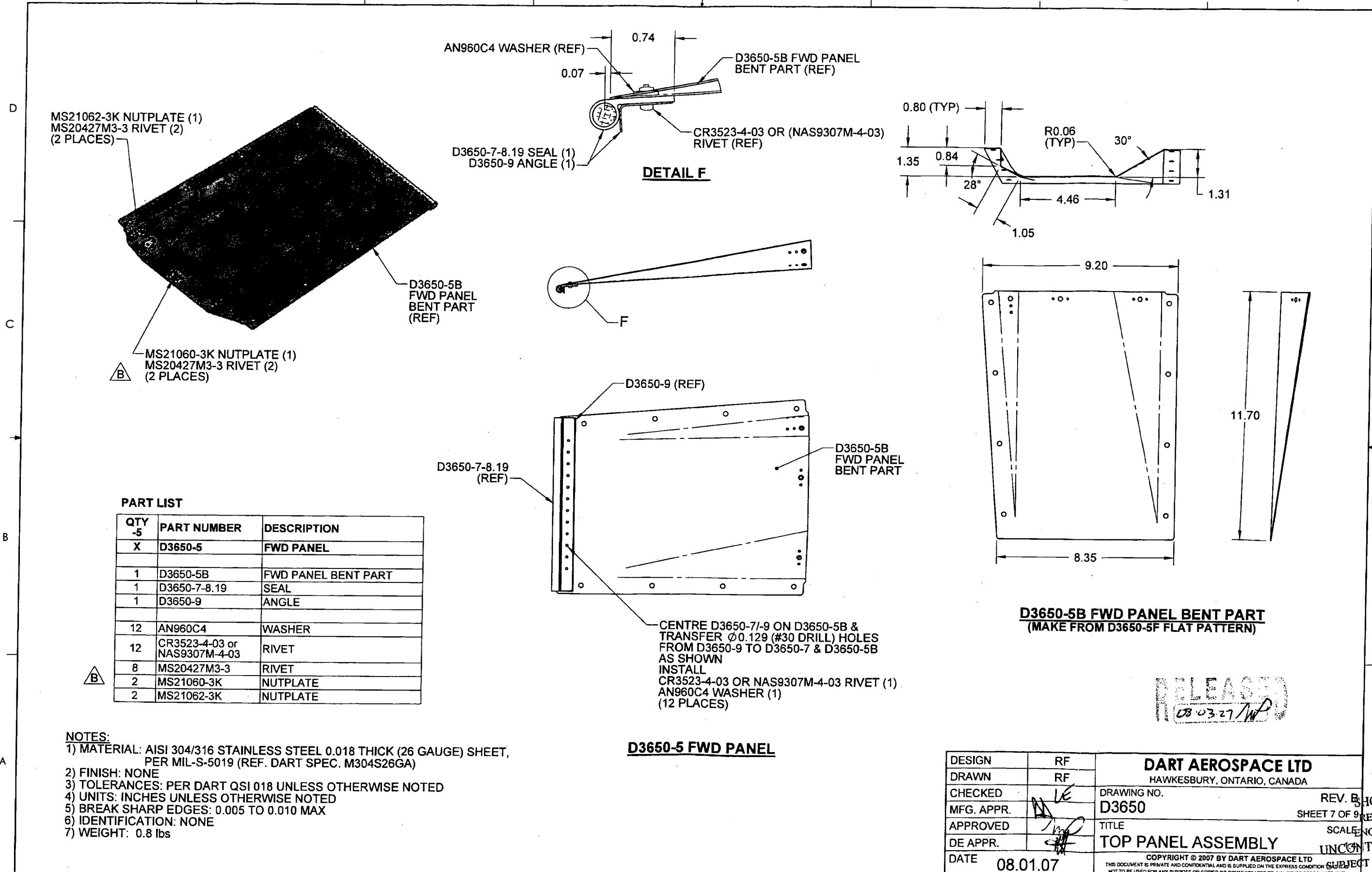


DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	M	D3650	SHOP COPY
APPROVED	M	TITLE	SHEET 6 OF 9
DE APPR.	M	TOP PANEL ASSEMBLY	RETURN TO ENGINEERING
DATE	08.01.07	UNCONTROLLED COPY SUBJECT TO AMENDMENT	

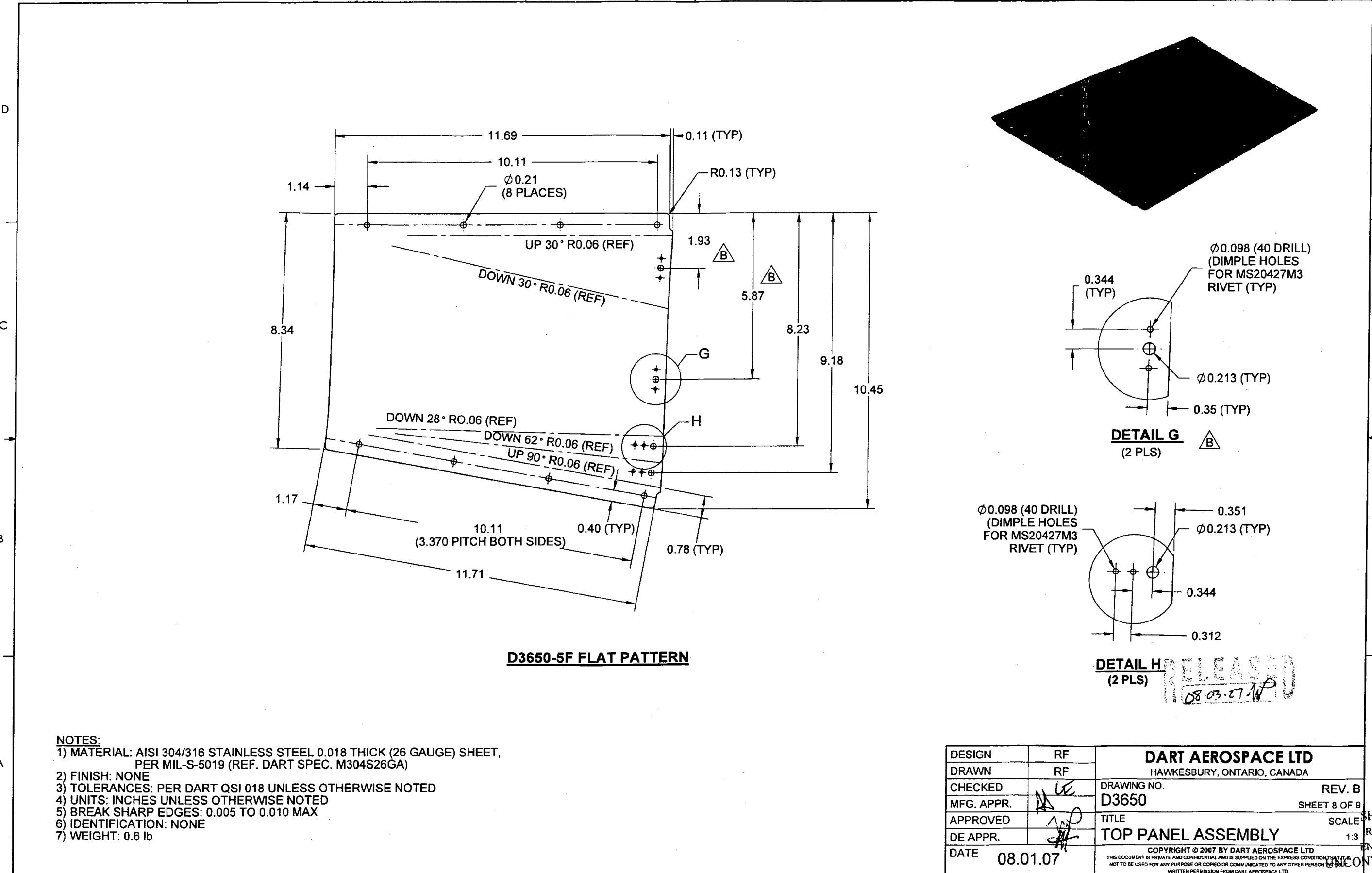
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WITHOUT NOTICE  
WORK ORDER  
NO. 110094

8 7 6 5 4 3 2 1

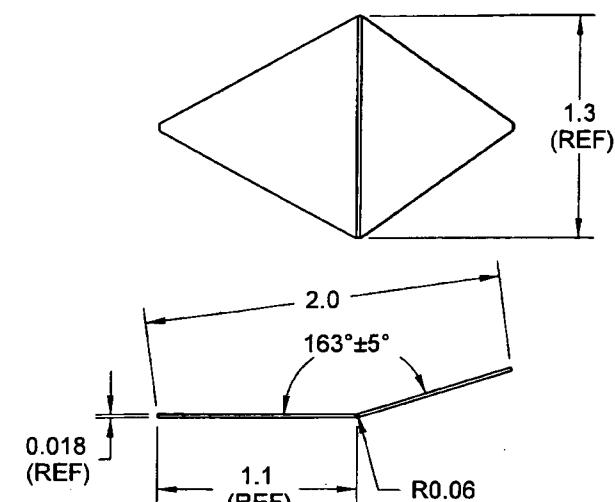


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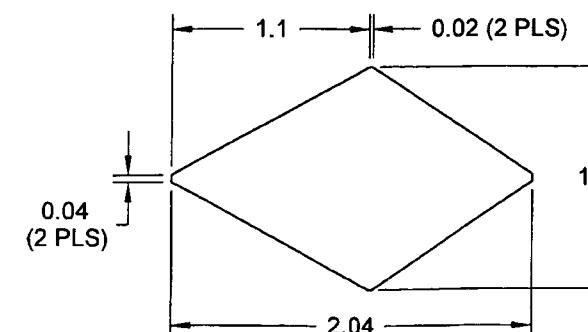


DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	LE	DRAWING NO.
MFG. APPR.	AS	D3650
APPROVED	AS	REV. B
DE APPR.	AS	SHEET 8 OF 9
DATE	08.01.07	TITLE
		TOP PANEL ASSEMBLY

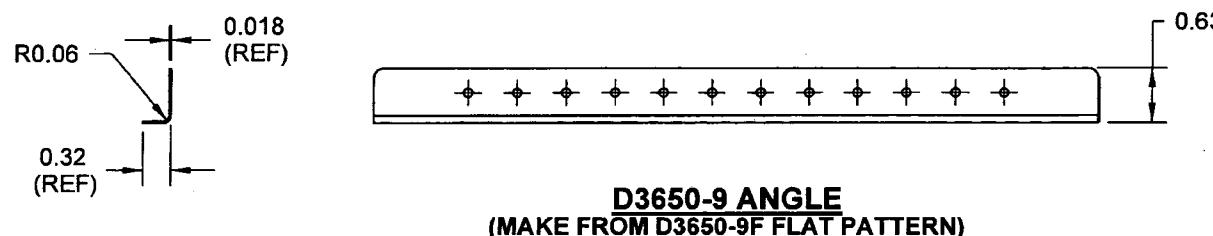
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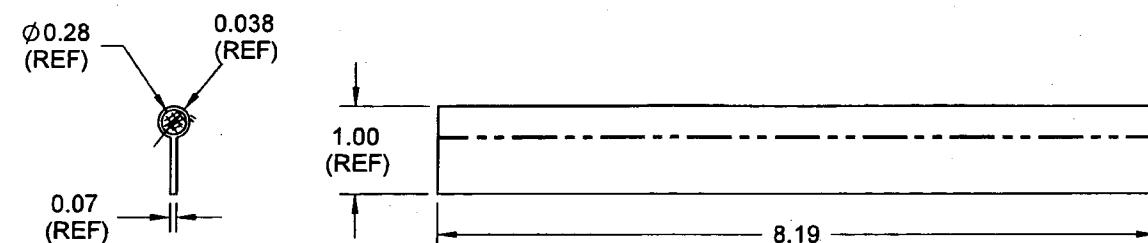
**D3650-11 FILLER PLATE  
(MAKE FROM D3650-11F FLAT PATTERN)**



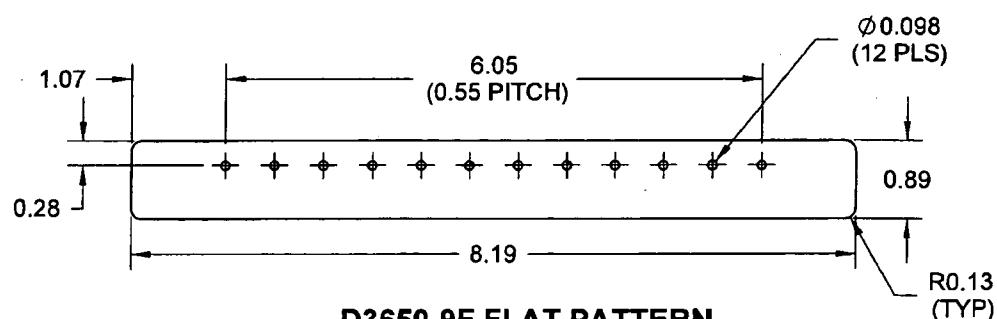
**D3650-11F FLAT PATTERN**  
(SCALE 1:1)



**D3650-9 ANGLE**  
**(MAKE FROM D3650-9F FLAT PATTERN)**



**D3650-7-8.19 SEAL**



## **D3650-9F FLAT PATTERN**

## D3650-9 & D3650-11 NOTES

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,  
PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) D3650-9 WEIGHT: 0.05 lb  
D3650-11 WEIGHT: 0.007 lb

D3650-7-8.19 NOTES

1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)  
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 0.05 lb

8) PART NUMBER: D3650-7-X.XX  
WHERE X.XX = LENGTH IN INCHES  
EG. 12.50" LONG = D3650-7-12.50

DESIGN	RF	DART AEROSPACE LTD		A
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>le</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>AM</i>	D3650	SHEET 9 OF 9	SHOP COPY
APPROVED	<i>JAY</i>	TITLE	SCALE	RETURN TO
DE APPR.	<i>CH</i>	TOP PANEL ASSEMBLY	1:2	ENGINEERING
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

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ET 9 OF 9  
SCALE 1:2  
INITIATED BY  
AMOUNT  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 45074